FONTARGEN A 203/6 M
Copper-tin wire electrode for MIG-welding

ISO 24373:   S Cu 5180 A (CuSn6P)
AWS A 5.7:   ERCuSn-A
Material-no.:   2.1022

Composition, typical analysis (% w/w)**:**

Sn	P	Cu
6	0.2	Remainder

Characteristics / Applications:

Welding of copper materials, e.g. CuSn-alloys, CuSnZnPb-cast alloys. Particularly well suited for the joint welding of brass on brass or brass on Cu-alloys, Fe-materials and cast iron. Suitable for welding of galvanised steel (MIG-brazing). Further applications include: Building-up of bearing bushes, sliding rails, repairs of phosphor bronze parts. For tin-bronze parts of > 10 mm thickness, we recommend preheating. Suitable for material numbers: 2.1010, 2.1016, 2.1020, 2.1030, 2.1050, 2.1052, 2.1056, 2.1080, 2.1086, 2.1090, 2.1096. Build-up welding on Fe materials should be performed by pulsed arc welding.

Corrosion- and overheating-resistant tin-bronze alloy. A 203/6 M is very easily machined and produces a clear weld pool. The welding deposit is tough and non-porous. Keep arc short. To eliminate contraction strains (in materials with high tin content) peen the seam.

Mechanical properties of pure welding deposit
(Min. values at room temperature):

Melting range: 910 - 1040 °C
Tensile strength: 260 N/mm²
Elongation (l=5d):   20 %
Thermal elongation: $18.1 \cdot 10^{-6}$/K
Hardness (Brinell):   80 HB
Electrical conductivity: 6 - 7 Sm/mm²
Heat conductivity: 75 W/m • K
Specific gravity: 8.7 g/cm³

Welding process: MIG

Shielding gas (DIN EN 439): I 1 (Argon)

Current mode: DC (+pole)

Availability: Diameter (mm): 0.8/1.0/1.2/1.6/2.0/2.4

Spool type: B300, S300

Welding position: according to DIN EN 287

PA	PB	PC	PD	PE	PF	PG
☒	☒	☒	☐	☒	☒	☐

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